

Date: Thursday, 12/15/2005 4:05:16 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PATIENT STOP
Job Number	: 25271		
Estimate Number	: 11490		
P.O. Number	: N/A	Part Number	: D2492
This Issue	: 12/15/2005 S.O. No. : N/A	Drawing Number	: D2492 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: D
Previous Run	: N/A	Material	: MAKE in multiples of 10
Written By	: SEE COMMENT BELOW	Due Date	: 12/23/2005 Qty: 10 Um: Each
Checked & Approved By	: SEE COMMENT BELOW		20
Comment	: Est. E 00.06.26 Removed P/O for powder coat EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 1.9140 sf(s)/Unit Total : 30.6247 sf(s)  
 5052-H32 .080 Sheet  
 Material: 5052-H32 (QQ-A-250/8) 0.080" thick  
 (M5052H32S.080)  
 Batch M19052

2.0	SHEAR	SHEAR
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Comment: SHEAR  
 Shear blanks: 8.000" x 25.942"

J.L 06.02.01 20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine per Folio FA041

J.L 06.02.01 19

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06.02.01 19

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 Deburr  
 Form using Jig DT2492B

DL 06/02/06 19  
 SAD 06/02/08 19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: SD Date: 06/02/16

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-02-01	3	- 1 part in stack of 10 was cut to short dimension is $8.000^{+0.030}$ and part is 7.938 didn't machine edges.		Scrap and destroy	SL 06-02-01	2 06-02-01		2 06-02-01

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PATIENT STOP

Job Number: 25271

Part Number: D2492

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*200209*

Comment: INSPECT WORK TO CURRENT STEP

910

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*06-02-12*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*06 02 10*

19

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 180*

*0206/02/15*

*(19)*

10.0

DC

DOCUMENT CONTROL



*(19)*

Comment: DOCUMENT CONTROL

Inspection Level 21

*505 06/02/16*

*(19)*

*06/02/16*

Job Completion



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-02-09	6.1	Add. Baseline as per Q51 005. 4.1 (check for approval)  Add to S.P.D. (permanent change)	E	06-02-16			 06-02-09

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/02/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

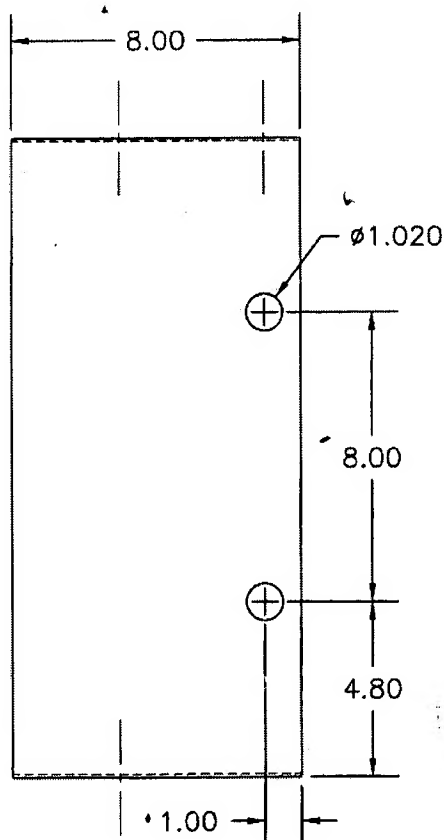
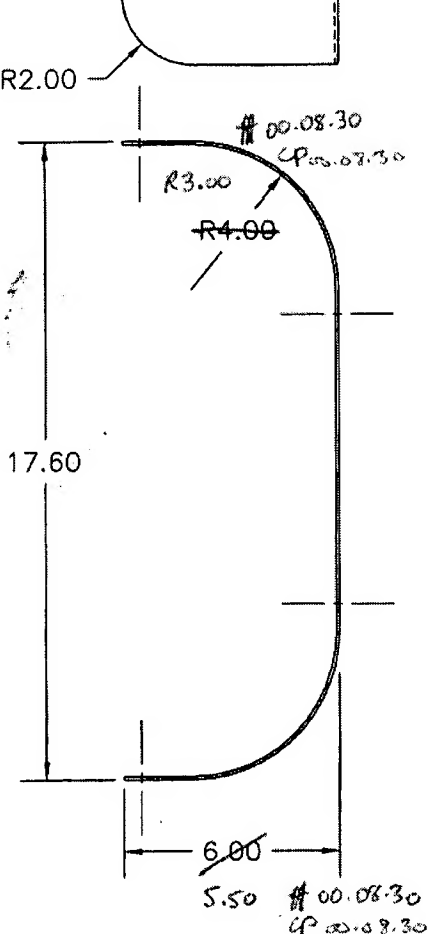
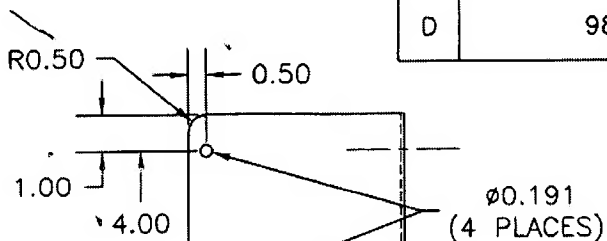
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <b>KE</b>	DRAWN BY <b>KE</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>KE</b>	APPROVED <b>KE</b>	DRAWING NO. D2492	REV. 0 SHEET 1 OF 1
DATE 98.05.11		TITLE PATIENT STOP	SCALE 1:5
A	95.10.24	NEW ISSUE	
B	96.02.28	MINOR CHANGES	
C	97.07.14	CHANGED MATERIAL AND FINISH	
D	98.05.11	R4.00 WAS R2.00 ADDED 8" WIDTH DIMENSION	

RELEASED  
98/06/15 KE



CHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
NOT TO  
BE USED

25271

MATERIAL: 5052-H32 QQ-A-250/8 0.080 THICK  
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

DART AEROSPACE LTD		Work Order:	25271
Description: patient stop		Part Number:	D 2492
Inspection Dwg: A2492 Rev: A			Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

[illegible]

Measured by: J.L.	Audited by: gml	Prototype Approval:
Date: 06-22-01	Date: 06/22/01	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	